

Work Order ID 58947

Thursday, May 20, 2010 10:32:43 AM



Page 1

Item ID: D2989-041

Accept



Setup Start



Revision ID:

Item Name: Basket Lid Assembly

Stop



Start Date: 5/25/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/2/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: PHDate: 10-5-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2989

Rev D

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989

2- tack weld mesh on basket as per dwg D2989 using DT9445 jig
****cut cutouts with zip cut as per dwg D3832****

3- remove from jig and weld lable plate as per dwg D2989

A/R ER316 S.S. Rod Batch: 111332810/05/27 (12)

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

10/05/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID:	D2989-041	Accept		Setup	Start	
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Item Name:	Basket Lid Assembly				Stop	
Start Date:	5/25/2010	Start Qty:	1.00			
Required Date:	6/2/2010	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

130	* PRESSURE WASH *	0.00							
	White Gloss(Ref.4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat	Memo	0.00							
Powder Coating									

← 1- Plug holes prior to powder coating
M 11/4/2007

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT:
 START TIME: 8:00AM
 OVEN TEMPERATURE: 400°F
 FINISH TIME: 8:30AM
 ***** 2nd coat if necessary *****

2ND COAT:
 START TIME: 8:45AM
 OVEN TEMPERATURE: 400°F
 FINISH TIME: 9:15AM

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

131



HandFinish

Wing Walk as per dwg QSI005 4.4 Batch *M 114432*

Memo

0.00

Hand Finishing

Mask lid prior to spray paint black and wing walk as per dwg
A/R Spray paint black batch *M 112549**① BR 10-5-31*

140



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

ES 10/05/31 ©

141



Packaging

Identify as per dwg & Stock Location: *G-A*

0.00

Memo

w/p 1358940 0.00

Packaging

ES 10/05/31 ©

W/O:		WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

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Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/01 *[Signature]*
CL10/06/01

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Picklist Print

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Page 1

Work Order ID: 58947

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 5/25/2010

Required Date: 6/2/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D2221-1



Rib

Manufactured No 100 Each 23.0000 2



10/05/25

Location

Loc Qty

Loc Code

WA

23

57182

1

57499

10

58122

12

②

✓ D2506



Label Plate

Manufactured No 100 Each 7.0000 1



10/05/27

Location

Loc Qty

Loc Code

WA

7

57599

2

57836

5

①

✓ D2512-7



Rib

Manufactured No 100 Each 8.0000 1



10/05/25

Location

Loc Qty

Loc Code

WA

8

56206

4

58026

4

②①

W/O:		WORK ORDER CHANGES					
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IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 5/25/2010

Required Date: 6/2/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D2581 Manufactured No 100 Each 44.0000 2



Mounting Bracket



MY 10/05/25

Location	Loc Qty	Loc Code
WA	44	
46086	2	
51745	2	
57185	1	
58301	19	②
58687	20	

✓ D2989-13 Manufactured No 100 Each 4.0000 2



Rib



MY 10/05/25

Location	Loc Qty	Loc Code
WA	4	
57769	4	②

✓ D2989-19 Manufactured No 100 Each 8.0000 2



Rib



MY 10/05/25

Location	Loc Qty	Loc Code
WA	8	
57770	4	
58085	4	②

W/O:		WORK ORDER CHANGES					
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IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 5/25/2010

Required Date: 6/2/2010

Start Qty: 1.00

Required Qty: 1.00

✓	D3832-3	Manufactured	No	100	Each	4.0000	1			<i>SL 10/05/26</i>
	Mesh (Lid)									
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
		WA		4						
		57187		1						①
		57833		3						
✓	D3833-3	Manufactured	No	100	Each	9.0000	2			<i>SL 10/05/26</i>
	Mesh (Lid End)									
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
		WA		9						
		46308		1						②
		53492		2						
		57626		6						
✓	D3836-041	Manufactured	No	100	Each	4.0000	1			<i>SL 10/05/25</i>
	Rib Assembly (Basket Lid, LH)									
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
		WA		4						
		57598		2						①
		58086		2						
✓	D3836-042	Manufactured	No	100	Each	3.0000	1			<i>SL 10/05/25</i>
	Rib Assembly (Basket Lid, RH)									
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
		WA		3						
		57597		1						①
		58087		2						

Thursday, May 20, 2010 10:32:47 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

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Start Date: 5/25/2010

Required Date: 6/2/2010

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
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IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

✓ D3852-041 Manufactured No 100 Each 4.0000 1

Rib Assembly

SY 10/05/25

Location	Loc Qty	Loc Code
WA	4	
57772	2	
58088	2	

①

✓ D3852-042 Manufactured No 100 Each 4.0000 1

Rib Assembly

SY 10/05/25

Location	Loc Qty	Loc Code
WA	4	
57771	2	
58089	2	

①

W/O:		WORK ORDER CHANGES					
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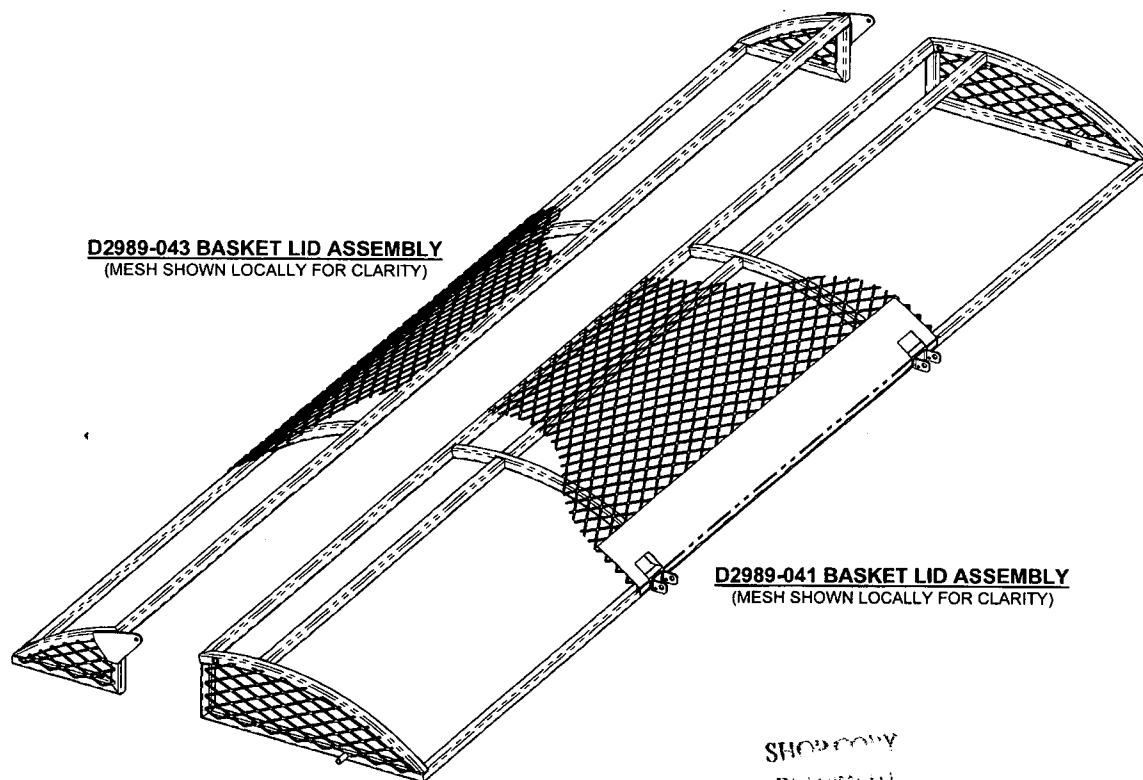
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NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)



D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58947
12/10-5-20

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
8/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (2N D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2, REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.05.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DS		
CHECKED	DS	DRAWING NO. D2989	REV. D
MFG. APPR.	DS		SHEET 1 OF 5
APPROVED	DS	TITLE BASKET LID ASSEMBLY	SCALE
DE APPR.	DS		NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

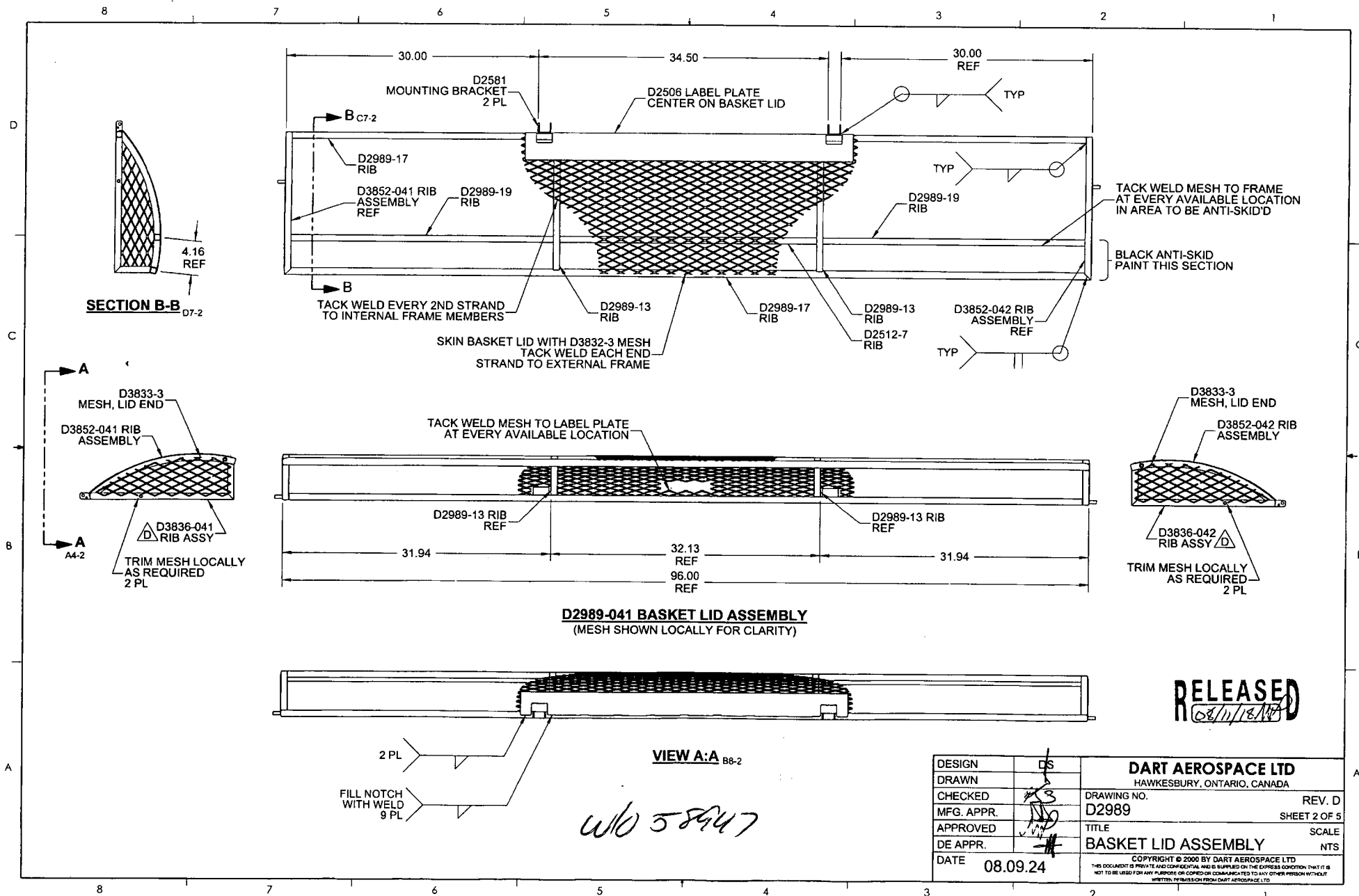
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DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

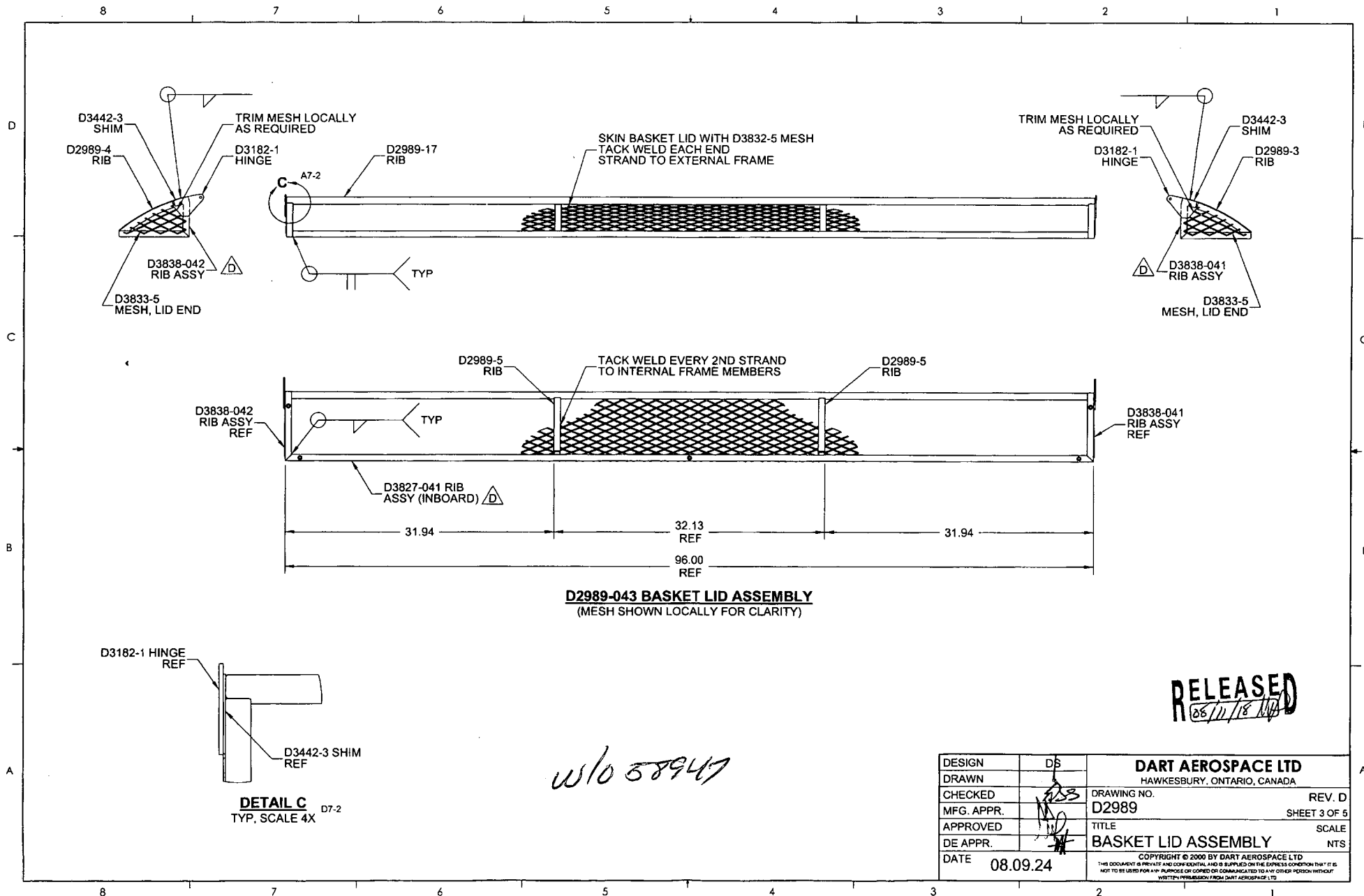
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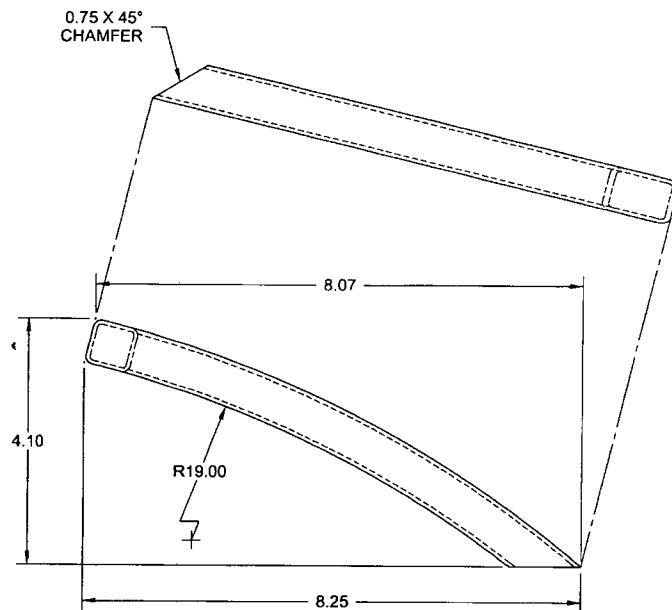
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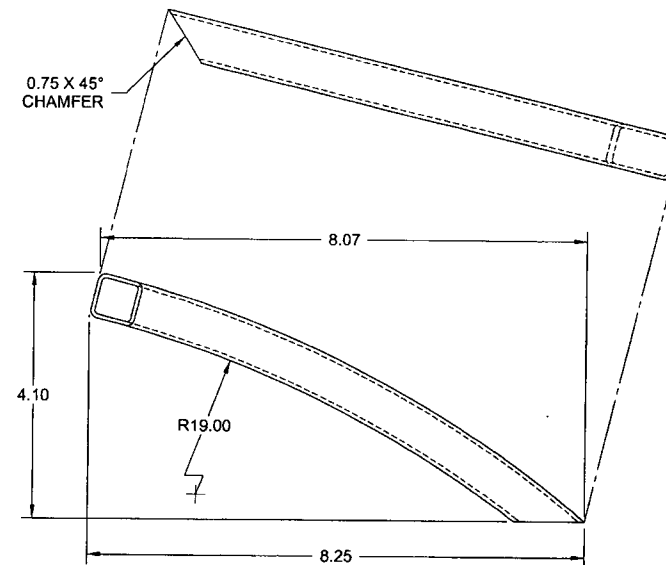
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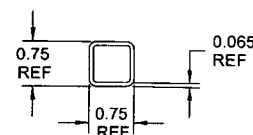


D2989-3 RIB



D2989-4 RIB

w/o 58947



TYPICAL SECTION VIEW

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18 NW

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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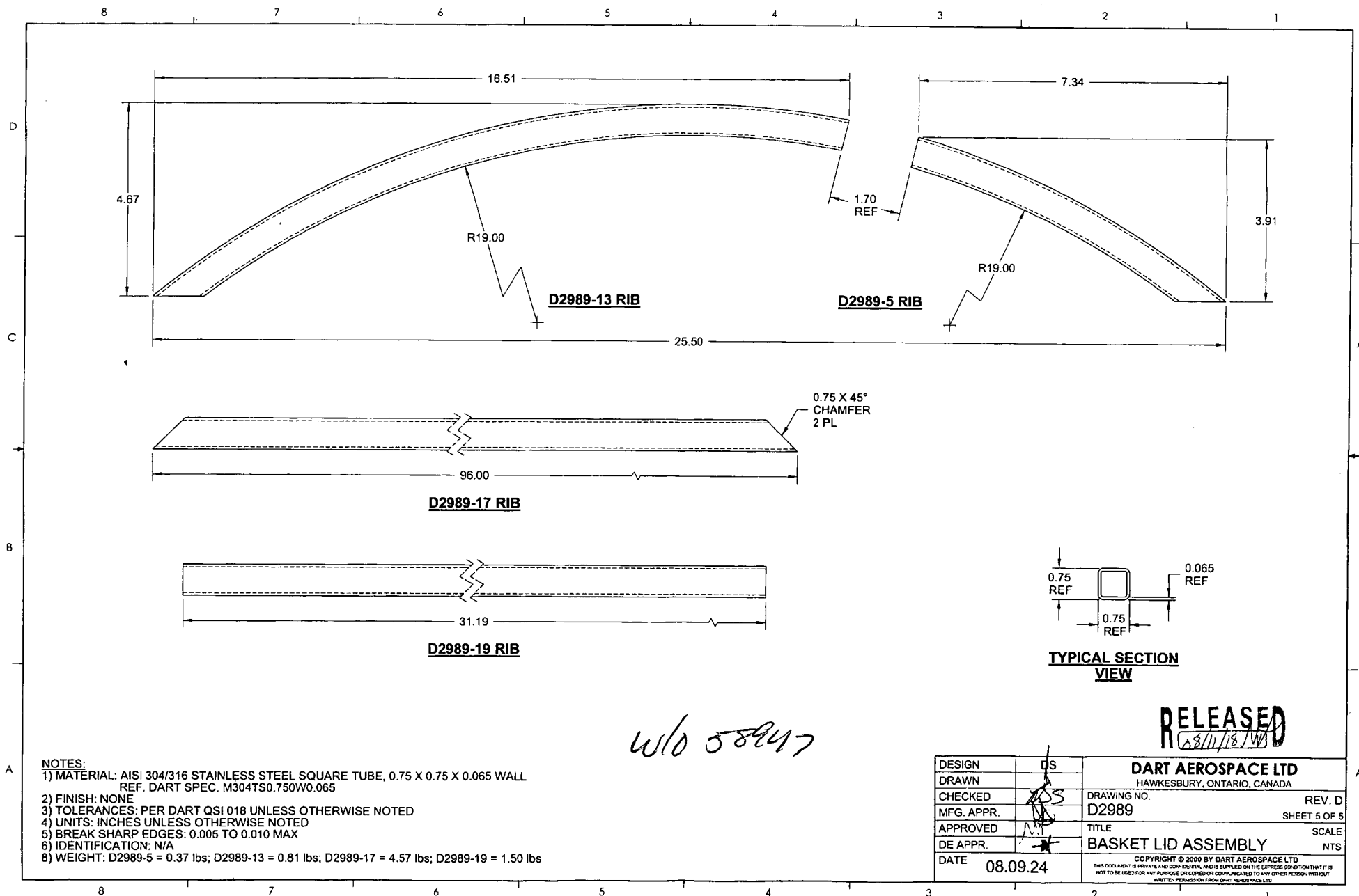
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries